

Date: Thursday, 15/01/2009 9:53:05 AM  
 User: Julie Crowson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 44798  
 Estimate Number : 10262  
 P.O. Number :  
 This Issue : 15/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D350636011  
 Drawing Number : D2750 REV F  
 Project Number : N/A  
 First Issue : / / Type : SKIDTUBES Drawing Revision : F  
 Previous Run : 44419 Material :  
 Due Date : 10/02/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 09.01.15  
 Comment :  
 Est Rev: I 02.09.25 Rearranged procedure steps KJ  
 Est Rev: J 06-03-23 As per Rev D JLM  
 Est Rev: K 06-07.13 As per ds19343 EC  
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM  
 Verified By: EC  
 Est Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 Est Rev: N 08-09-23 rev F as per dwg DD verified by: ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for 2D 09/02/02



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

09/02/02

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2600-3-Bent Extrusion (Bent) B-43495

AWM  
7-1-16

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B427B 09/01/19

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

AWM  
7-1-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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- |    |   |  |
|----|---|--|
| 3- | Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.   |  |
| 4- | drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"           |  |
| 5- | locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting |  |

6-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m109560 BB 09/01/09*

10-Grind welds flush as per Dwg D2750

12- Scribe batch# inside per dwg D2750

*AWM 9-1-16*

*SL 9-1-16*

*AWM 9-1-19*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*S 09/01/20 (40)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/01/20 (40)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*AWM 9-1-21*

*(1)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP 9-1-21*

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44798

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B-44885

ANM

9-1-22

(1)

10.0	D34901	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

44796

BE 9-1-23

11.0	D34903	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

44901

BE 9-1-23

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

443110

BE 9-1-23

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on  
sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

ANM 9-1-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

M109 883  
9-7-7

ANM 9-1-22

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R

Aluminum Rod

batch:

M110295 JE 9-1-26

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11-Deburr holes

ANM 9-1-26

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 09/01/27 8 09/01/26

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/26 (XL)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

MS

09-01-28

(XU)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M109996.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

15:20  
320°  
15:50

BR 09-01-28

(D)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

MS 09-01-29 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 44798

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M 109813

JA

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1- Install inserts as per Dwg D2750

JA

09-01-29

(X)

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: B43754

JA

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B43890

JA

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B44062

JA

24.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B44913

JA

25.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B43891

JA

09-01-29

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 44798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B43892

*Handwritten initials*

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B44060

*Handwritten initials*

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B44061

*Handwritten initials*

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B44649

*Handwritten initials*

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B40909

*Handwritten initials*

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B41206

*Handwritten initials*

32.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

X NAS1611-010 batch: M110713  
(or MS28775-010) batch: \_\_\_\_\_

*Handwritten signature and date*  
09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

batch: M1106513

911

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: M110715 1943815

21

35.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: (4x) B42997 / (4x) B44216

911

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Bolt

Batch: M110581

911

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M1108880

911

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M110105

911

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M110105

911

09.01.29

911

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 44798

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)  
washer

Batch: M110139

24

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WASHER

Batch: M110139

24

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
NUT

Batch: M110180

24

43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
NUT

Batch: M110584

24

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
WASHER

Batch: M110450

24

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: M109539

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M109833

EXP DATE: 09/11

4109-01-30 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4-assemble o-ring as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M101223

5-Coat all exposed fasteners with "LPS Procyon" batch: NY104251

15/01/2009 (X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15/02/02 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 42222

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M112139

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

15/02/02 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 1710468

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 44886

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: 1344643

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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62 09 22 MP

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA	DART AEROSPACE USA, INC.	
DRAWN		DRAWING NO. REV. F	
CHECKED		D2750 SHEET 1 OF 11	
MFG. APPR.		TITLE SCALE	
APPROVED		350 SKIDTUBE ASSEMBLY NTS	
DE APPR.		DATE 08.07.16	
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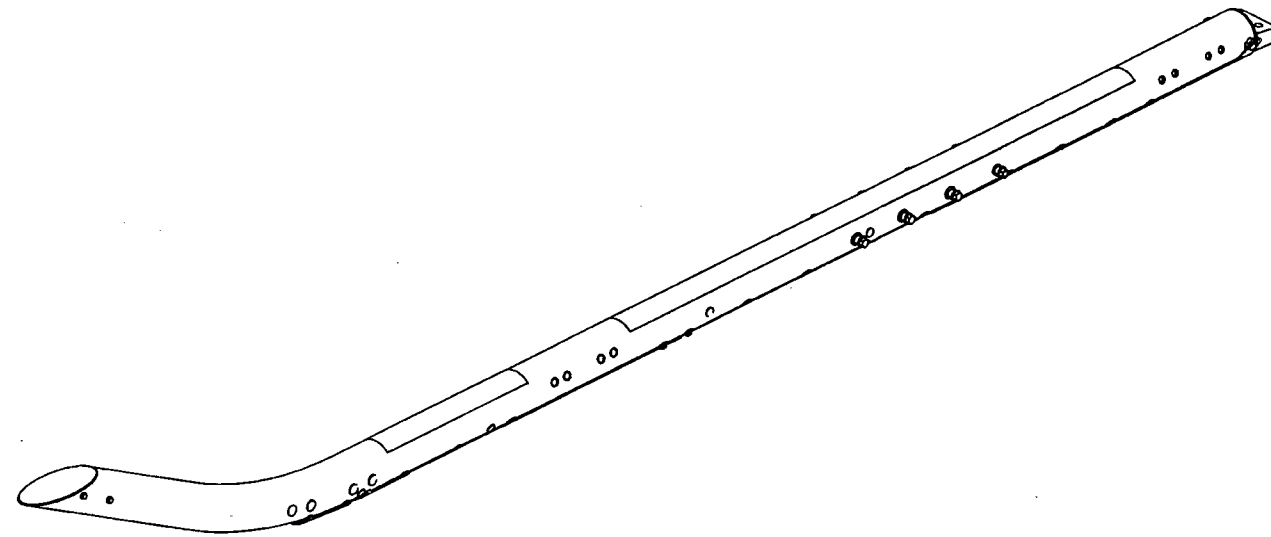
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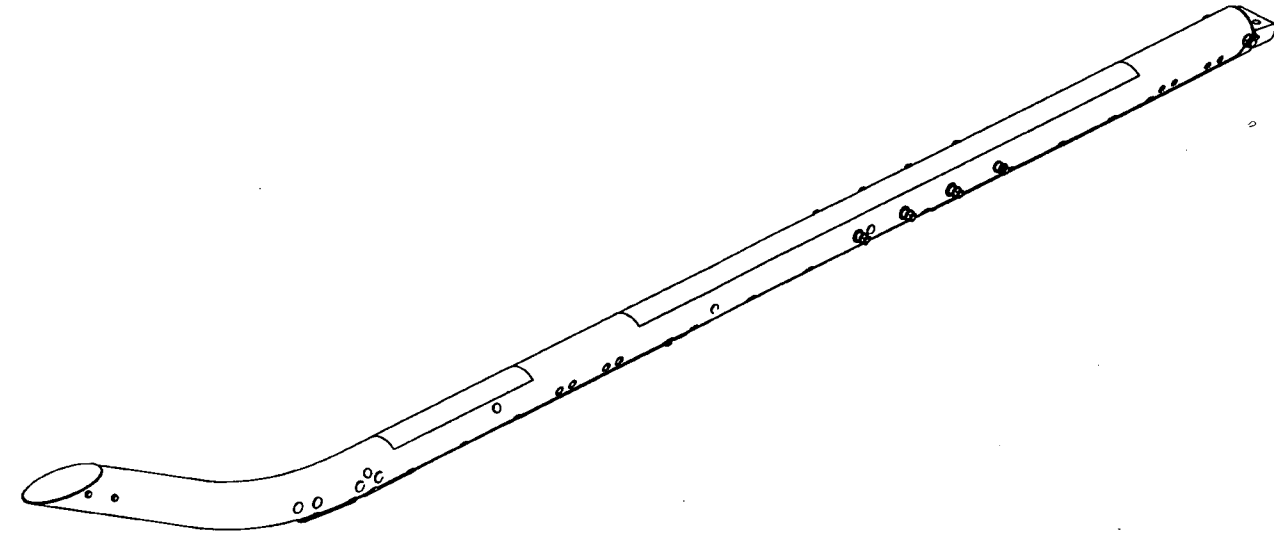
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B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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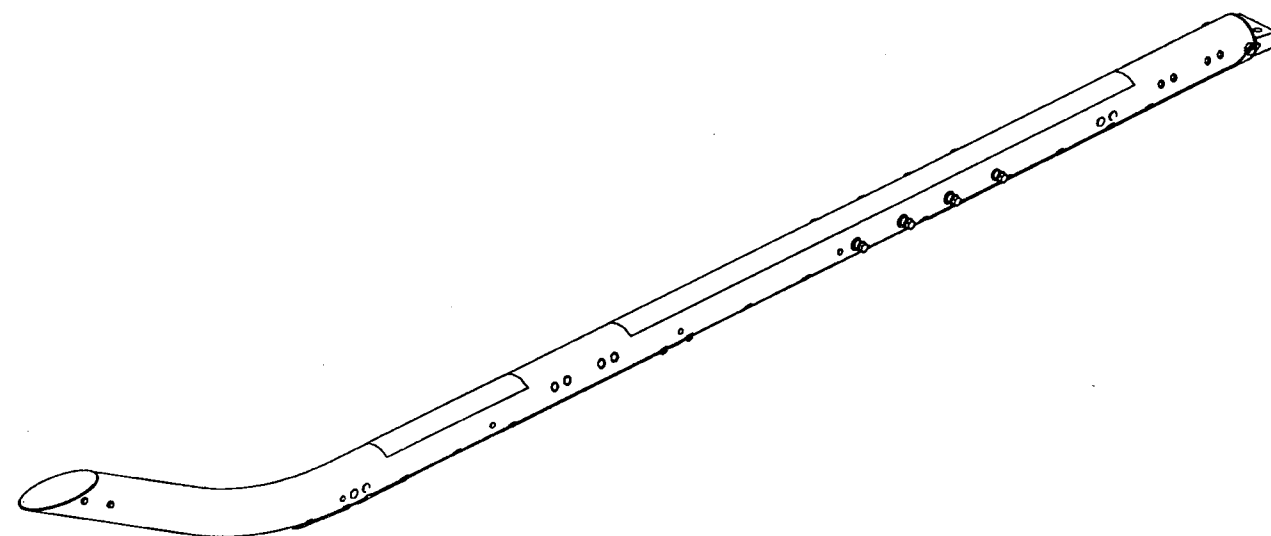
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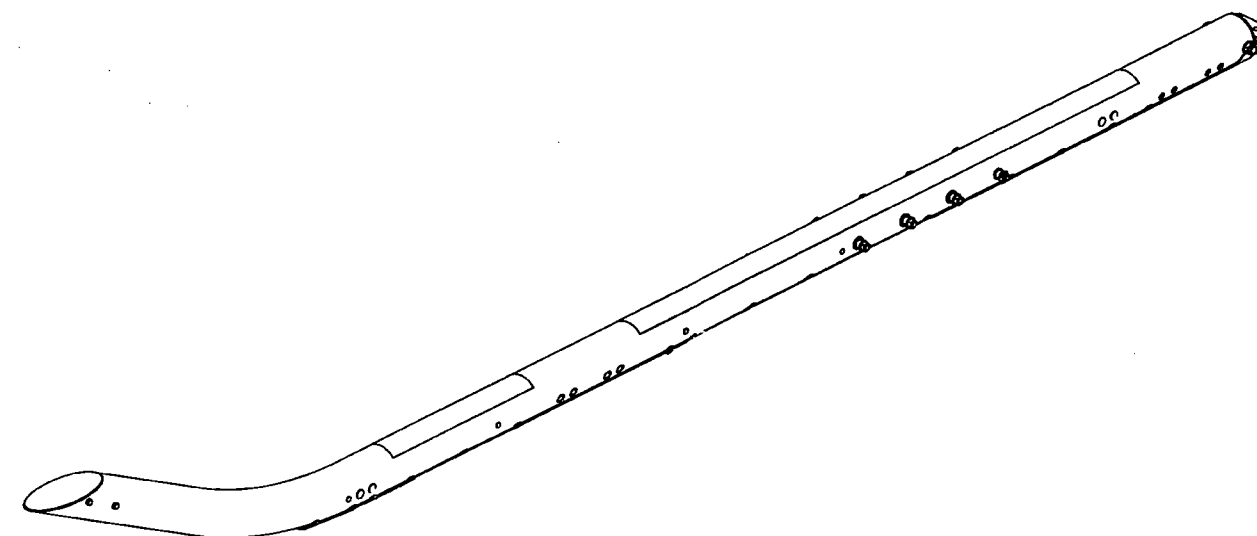
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

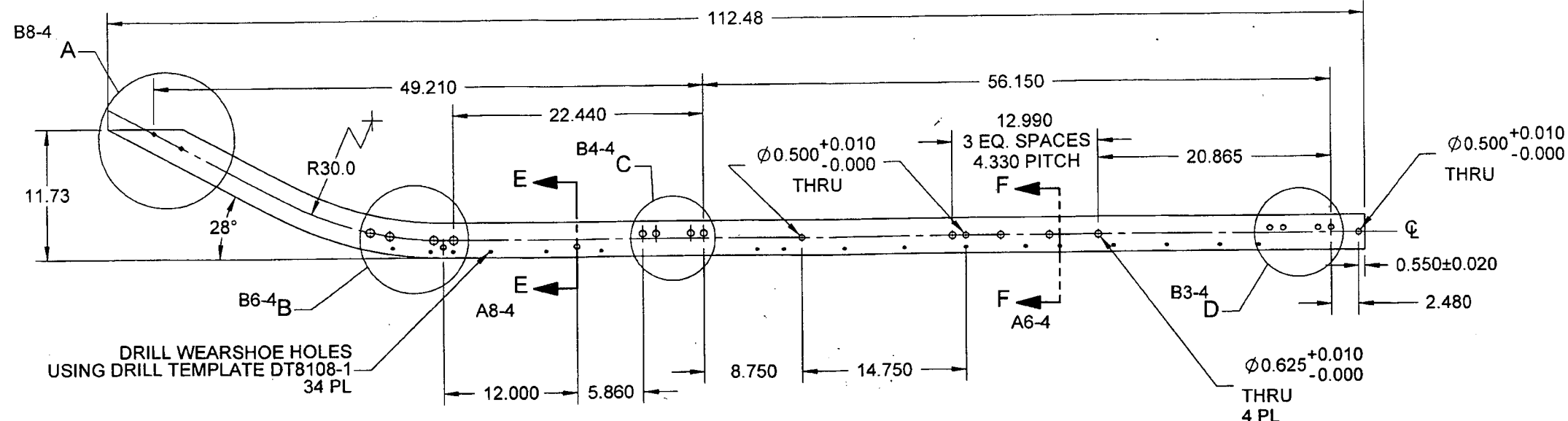
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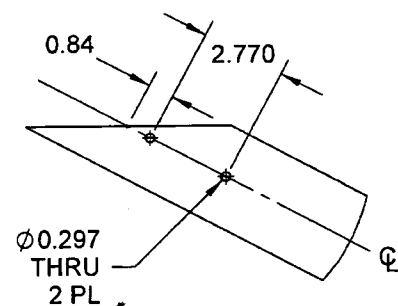
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MFG. APPR.	MA	D2750	SHEET 3 OF 11
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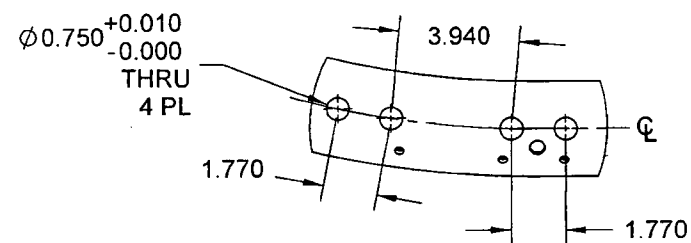




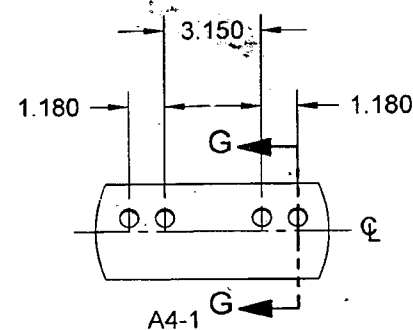
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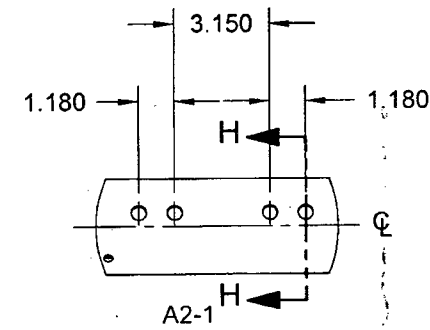
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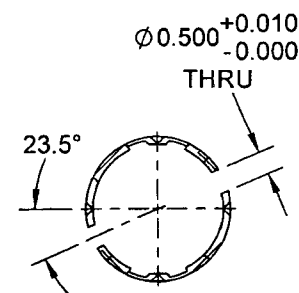
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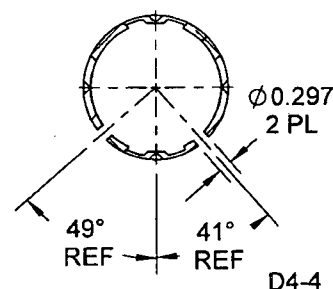
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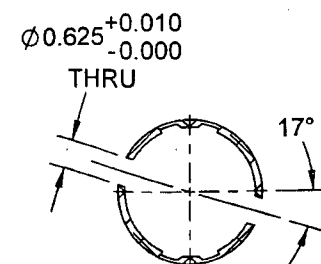
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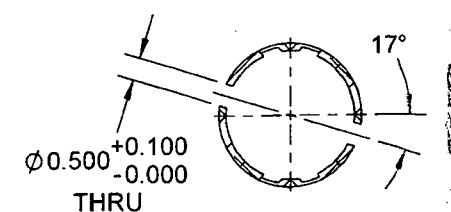
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL




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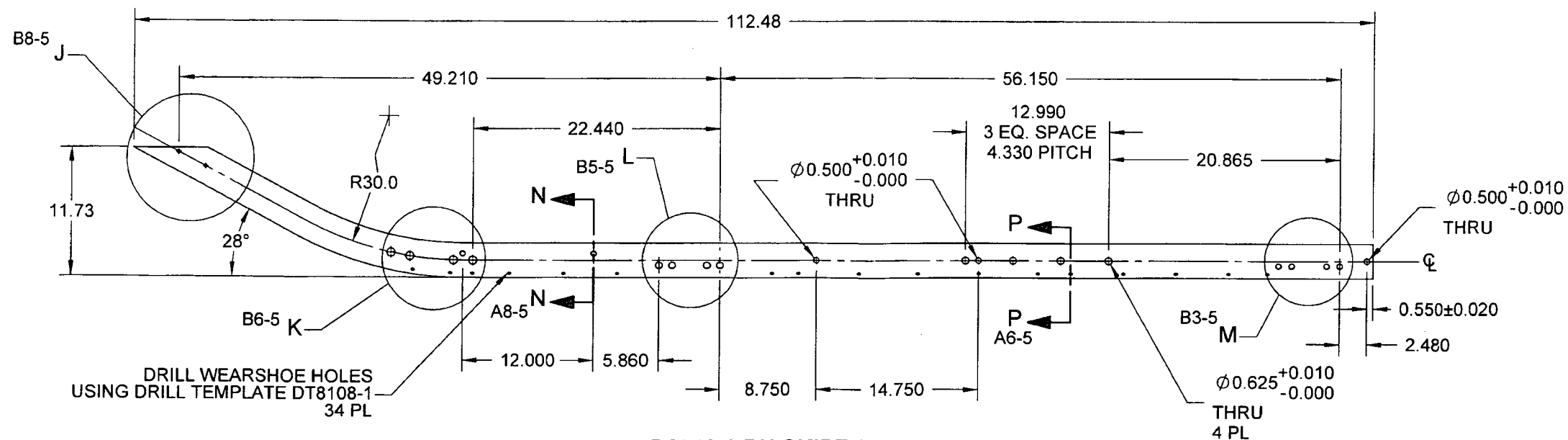
**SECTION H-H**  
SCALE 3X, 4 PL

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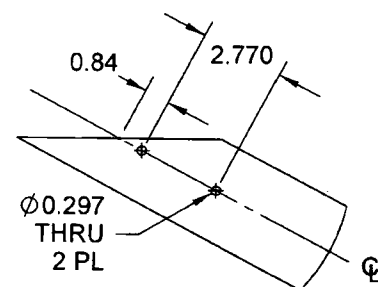
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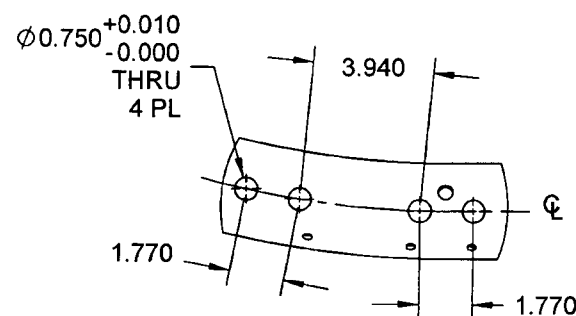




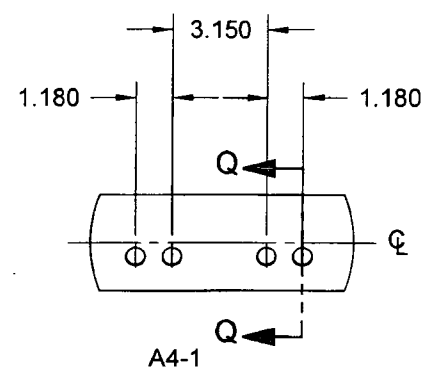
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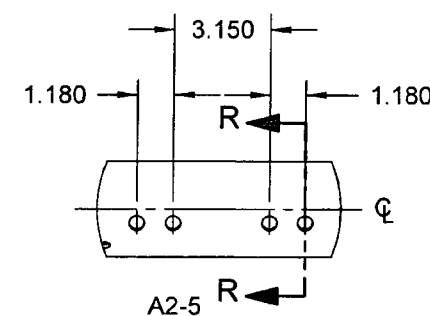
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**DETAIL K**  
SCALE 2X



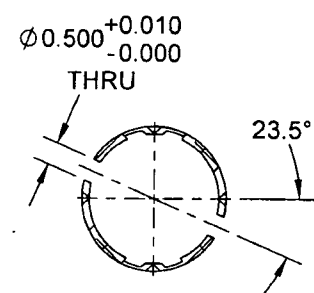
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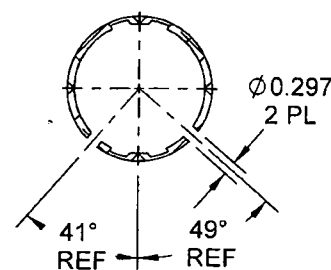
**DETAIL M**  
SCALE 2X

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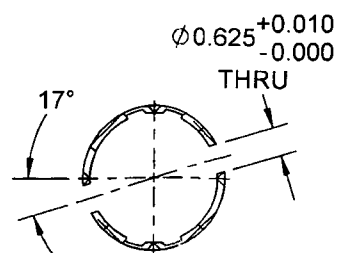
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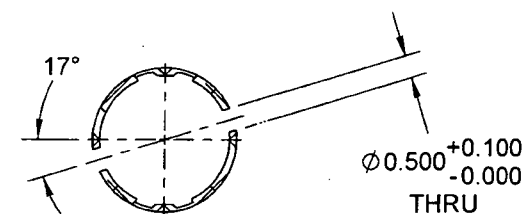
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



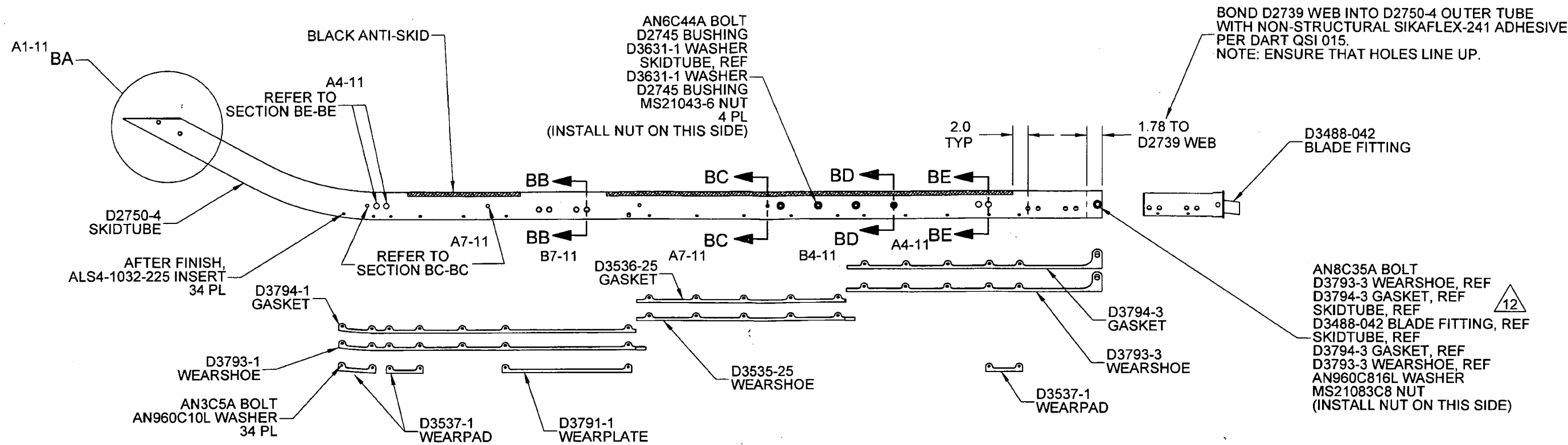
**SECTION Q-Q**  
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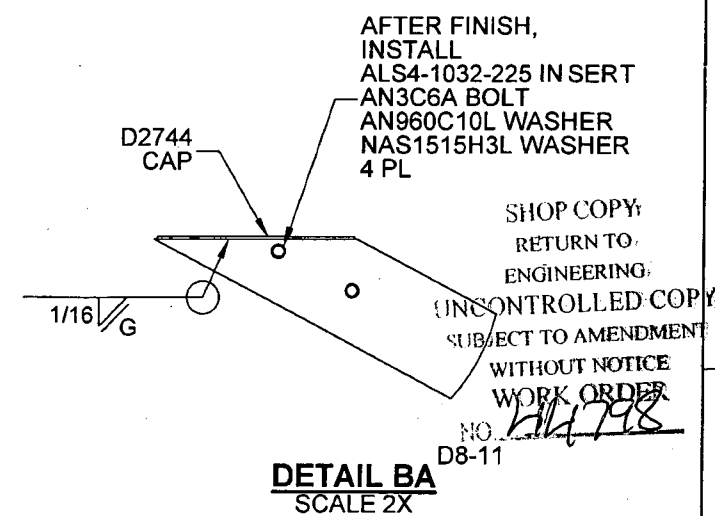
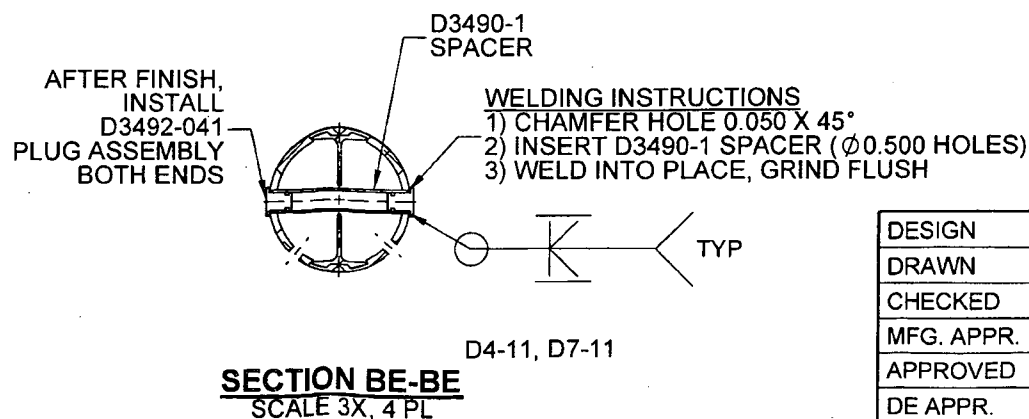
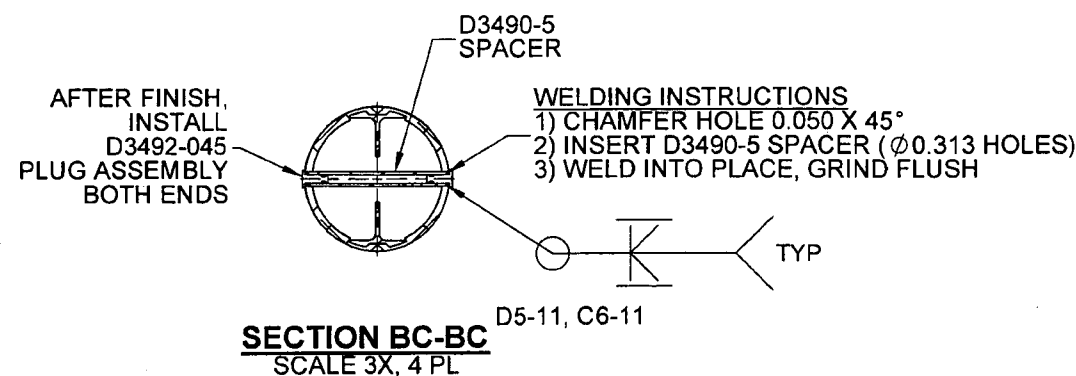
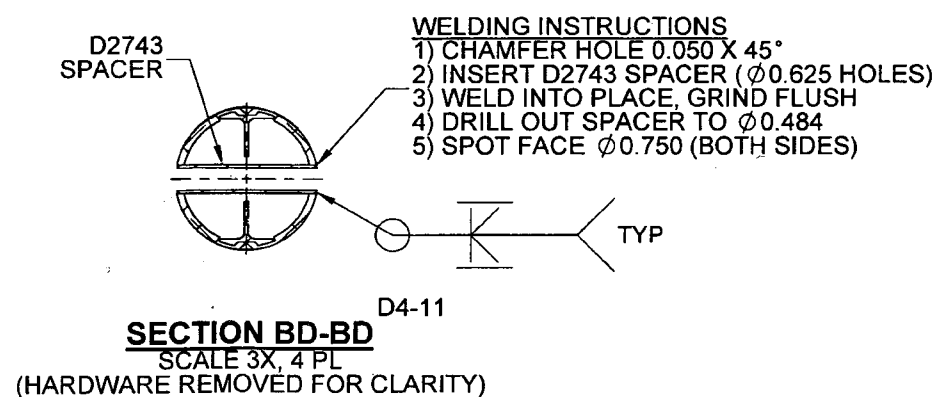
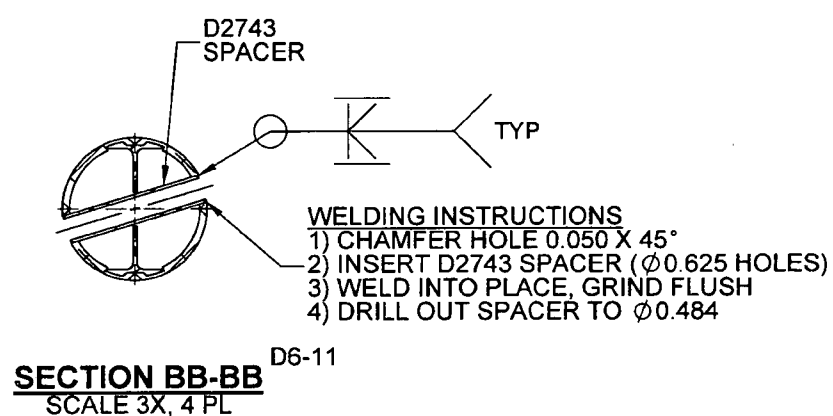
**SECTION R-R**  
SCALE 3X, 4 PL







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**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



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**RELEASED**



NO. 190

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Bardley Elliot  
Job number: 44808  
Part number: D350 626 0119  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pet. D. Date of Test Coupon 09-01-27  
Welder Bardley Elliot Date of Test Coupon 09-01-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

# ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

Attendees:

MATERIAL

Report Type:

Subject:

Venue:

Date:

Sheet \_\_\_\_\_ of \_\_\_\_\_

Item	Action / Description	Responsible	Due Date	Action / Date
* M6061T6T51000W120-SQUARE FLAT	Need 224' - flat - <input type="checkbox"/>	Order -	140'	
	337' O/H.			
	224' ALL.			
	M6061T6T200W0125.			
	O/H x 20'.			
	ALL .5'			
* M6061T6T1250W125.	O/H 110'.	Order	160'	
	ALL 235'			
* M6061T6B0250 x 06000.	O/H - 27'	60'		
	ALL - 29'			
	M6061T6T1125W058			
	O/H - 13'			
	ALL - 1,7'			
* M6061T6T1500W125	O/H - 32'	5, 2 / each	60'	
	ALL - 52'			
* M6061T6T100W125.	19' O/H.	- 12' -		
	8,7' ALL.			



# ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

Attendees:

Report Type:

Subject:

MATERIAL SHEET

Venue:

Date:

Sheet of

Item	Action / Description	Responsible	Due Date	Action / Date
	m6061T6T1000W065X100'.? 417' OH. 416 ALL.			
	m6061T6S125 - STOCK			
	m2024T3S032 87' OH. 54' ALL.	→ best/wed 192 <sup>2</sup>		
	m6061T6T0875W0125 OH - 40' ALL - 5'			
	m6061T6R0500 85' OH. 8,4' ALL			
	m6061T6R0625 96' OH. 3,3' ALL.			
	m6061T6R1500. 21' OH. 0.5' ALL.			
	m6061T6S090. 82' OH. 36' ALL.			

# ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

Attendees:

Report Type:

Subject:

Venue:

Date:

Sheet \_\_\_\_\_ of \_\_\_\_\_

Item	Action / Description	Responsible	Due Date	Action / Date
	m 304 R0750.			
	32' O/H.			
	1,1 ALL			
	m7075 T6 R2000.			
	12' - O/H.			
	78' - ALL			
	m7075 T6 B1500x1500			
	17' O/H.			
	7' ALL			
	m6061 T6 T1750W065.			
	146'.			
	ALL: 77.66'			